

Spil

Work Order ID 94269-2

December-03-12 12:31:09 PM

\*94269\*

Page 1

Item ID: D3651-043

Revision ID:

Item Name: Flange Weldment

Start Date: 04/12/2012 Start Qty: 5.00

Required Date: 18/12/2012 Req'd Qty: 5.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MCT

QC:

Date: 12-12-04

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3651

Rev B

100

\*100\*

Large Fab

Large Fab

Large Fab

0.00

Memo

Weld assembly as per dwg D3651

0.00

110

\*110\*

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

120

\*120\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Q 12-12-5

Q 12-12-5

045  
09

Q 12-12-5

045  
09

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>		
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 94269

December-04-12 12:34:09 PM

\*94269\*

Page 2

Item ID: D3651-043

Revision ID:

Item Name: Flange Weldment

Start Date: 04/12/2012 Start Qty: 5.00

Required Date: 18/12/2012 Req'd Qty: 5.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

\*130\*

Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D3651

0.00

0.00

2

0

FF  
12-12-10

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

AS  
15  
12/12/11

2

150

\*150\*

Packaging

Packaging

Identify as per dwg & Stock Location: GA

Memo

0.00

0.00

2

SB  
12/12/11

2013

# Work Order ID 94269

December-04-12 12:31:09 PM

\*94269\*

Page 3

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Required Date: 18/12/2012 Req'd Qty: 5.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

160

\*160\*

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

12/12/11

YMF  
12-12-11





# Picklist Print

December-04-12 12:31:13 PM

Page 1

Work Order ID: 94269

Parent Item: D3651-043

Parent Item Name: Flange Weldment

\*94269\*

\*D3651-043\*

Start Date: 04/12/2012

Required Date: 18/12/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP Rev:A New Issue 07-09-27 DD verified by: EC  
 IPP Rev:B ECN 1113P 08-01-22 DD  
 IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3651-5 *D3651-5* Top Flange		Manufactured	No			100	Each	0.0000	1	5			
D3651-7 *D3651-7* Bottom Flange		Manufactured	No			100	Each	0.0000	1	5			
CR3523-4-02 *CR3523-4-02* RIVET		Purchased	No			130	Each	830.0000	57	285			

## Location

## Loc Qty

## Loc Code

GA 160  
 120308 100  
 121114 60  
 ST312 454  
 123164 454  
 ST330 216  
 116893 3  
 116915 1  
 120422 15  
 120873 197

FF 12-12-10

D3651-3

\*D3651-3\*

Base

Manufactured No

130 Each

1.0000

1

5

\*\*

## Location

## Loc Qty

## Loc Code

GA 1  
 82553 1

FF 12-12-10

2





# Picklist Print

December-04-12 12:31:13 PM

Page 2

Work Order ID: 94269

Parent Item: D3651-043

Parent Item Name: Flange Weldment

\*94269\*

\*D3651-043\*

Start Date: 04/12/2012

Required Date: 18/12/2012

Start Qty: 5.00

Required Qty: 5.00

MS20427M3-3

Purchased

No

\*MS20427M3-3\*

Rivet

130 Each 1.257.000 16 80  
\*\*

FF 12-12-10

## Location

## Loc Qty

## Loc Code

GA

1242

123352

1242

ST335

15

120930

3

123021

12

MS21060-3K

Purchased

No

\*MS21060-3K\*

Nut Plate

130 Each 123.0000 8 40  
\*\*

FF 12-12-10

## Location

## Loc Qty

## Loc Code

ST316

123

116857

17

117423

13

117977

15

118267

1

123168

77

16

December-04-12 12:31:13 PM

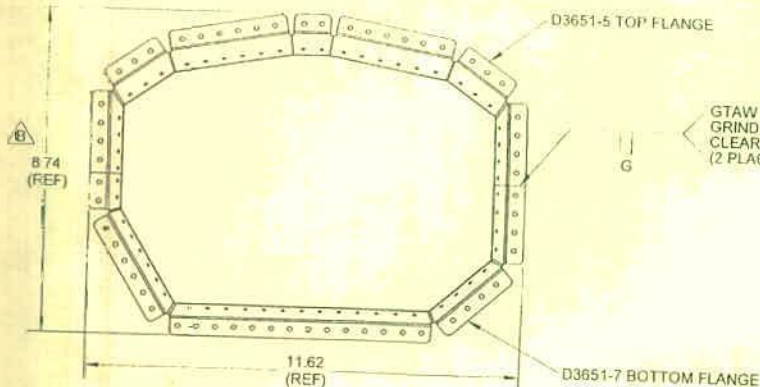
Shop Packet Print

Page 2



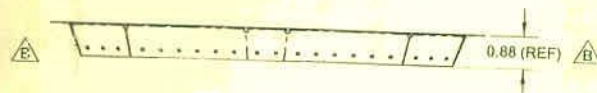
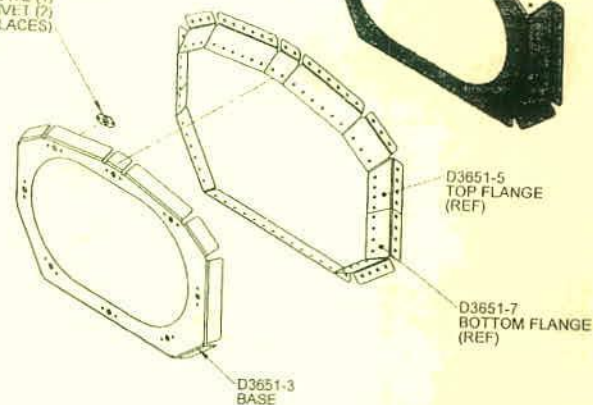


TRANSFER DRILL - Ø 129 (#30 DRILL)  
FROM D3651-5/7 TO D3651-3  
INSTALL CR3523-4-02 OR NAS9307M-4-02  
RIVETS (57)



GTAW  
GRIND FLAT TO  
CLEAR FASTENERS  
(2 PLACES)

MS21060-3K NUTPLATE (1)  
MS20427M3-3 RIVET (7)  
(8 PLACES)



**D3651-043 FLANGE WELDMENT**

94269 MLS  
12-12-04

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NAS9307M-4-02	RIVET

**D3651-043 NOTES:**

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER BART C.SI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO. D3651	REV. B
MFG APPR	LE	TITLE AFT BASE ASSEMBLY	SHEET 2 OF 9
APPROVED	LE	SCALE 1:3	
DE APPR	LE	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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